

# ABSTRACT OF THE DISCLOSURE

A rim member 120 forming an entrance 110 and a plate 11 (21) are friction stir welded by moving a rotary tool 200 along the rim member 120. The rotary tool 120 is tilted along the direction of movement. Welding is started at right block 120R, and when the tool reaches corner portion P5 between the right block 120R and a center block 120C, the tool 200 is pulled out of the rim member 120 and plate 11 (21). Next, the tool is tilted toward the direction of movement along center block 120C. Thereafter, the tool is lowered and inserted to position, and friction stir welding is restarted. According to the invention, the direction of the rotary tool is not changed while the tool is inserted to the rim member 120. This prevents generation of excessive friction heat, and thereby realizes a good weld. (FIG. 1)